

Date: Thursday, 05/02/2009 3:29:54 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MONOPOD ASS'Y
 Job Number : 45527
 Estimate Number : 13177
 P.O. Number :
 This Issue : 05/02/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D3686041
 First Issue : / / Type : MACHINED PARTS Drawing Number : D3686 REV C
 Previous Run : 45217 Drawing Revision : C
 Material :
 Due Date : 10/02/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JUD 09.02.06
 Comment : Est Rev:A new issue 08-02-12 DD verified by:JLM
 Est Rev:B As per Rev B 09-01-07 JLM Verified By:EC
 Est Rev:C Added serial note as per Rev C 09-01-20 JLM
 Verified By:DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

2.0 D36887 STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

STUD

batch

344686

JP

3.0 D36891 SLEEVE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

SLEEVE

batch

B44825

SC

4.0 D36911 STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

STUD

batch

44485

44826

SC

5.0 D36921 SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

SPACER

batch

44689

9626

SC

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:29:54 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MONOPOD ASS'Y

Job Number: 45527

Part Number: D3686041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D36923	SPACER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
SPACER
batch 44728

SP

7.0	D36931	Rod End Bearing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Rod End Bearing
batch B44691

SP

8.0	D36933	Rod End Bearing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Rod End Bearing
batch B36880

SP

9.0	AN3C10A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt

M105940

SP

10.0	AN3C12A	Bolts
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolts
batch M110584

SP

11.0	MS210433	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
batch M110623

SP

12.0	NAS509L12C	Nuts
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Nuts
batch M106993

91266

Q

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: MONOPOD ASS'Y

Job Number: 45527

Part Number: D3686041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

NAS50912C

Nuts



1X

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nuts

batch M106993

9/2/6

SD

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3686

M110658

AS

090209

2-Assemble D3693-1 & D3691-1 & D3693-3 & D3688-7 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3686

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3686

AS

090209

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S090209 @

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

PPP 45521

AS

090210

@

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

090210

Job Completion



U 09.02.10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

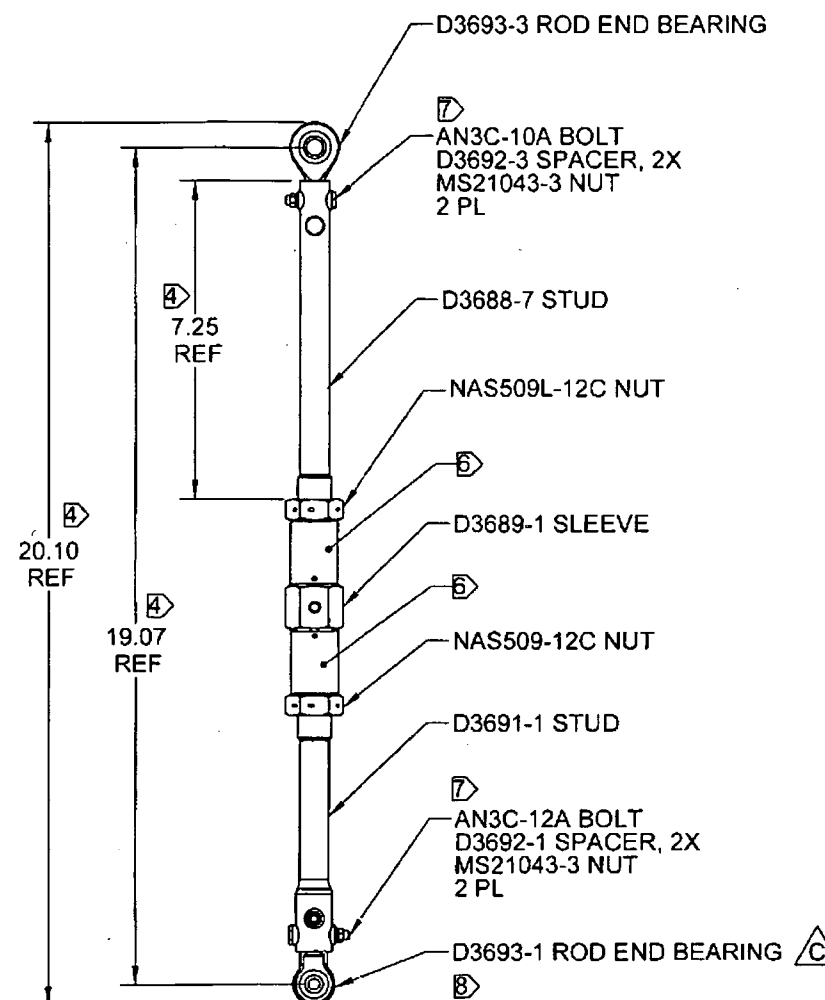
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3686-041	MONOPOD ASSEMBLY
2	1	D3688-7	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	4	D3692-3	SPACER
7	1	D3693-1	ROD END BEARING
8	1	D3693-3	ROD END BEARING
9	2	AN3C-10A	BOLT
10	2	AN3C-12A	BOLT
11	4	MS21043-3	NUT
12	1	NAS509L-12C	NUT
13	1	NAS509-12C	NUT



D3686-041 MONOPOD ASSEMBLY

RELEASED
09/01/12

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3686-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-7 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.0 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 & D3693-3 WITH D3688-7 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

C	ROD END BEARINGS NOW ASSEMBLED USING SEALANT (ZN A8-1, B4-1)	RF	08.12.15
B	REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3686	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		MONOPOD ASSEMBLY	UNITS
DATE	08.12.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CORPUS OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

